



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3910-1
Job Sheet 167535



Part No: D3910-1

Job Qty: 30 ea

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/2/17

Job Tracking No:

Due Date: 11/17/17

Created By: Chantal Lavoie

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	30 pcs		11/16/17	0.00	0.00	Purchasing		Chantal Lavoie 17-12-22
120	Packaging	30 pcs		11/16/17	0.00	0.00	Packaging2		Chantal Lavoie 17-12-22
130	QC	30 pcs		11/16/17	0.00	0.00	QC6		38
140	HandFinish	30 pcs		11/16/17	0.00	0.41	HandFinish1		9-89
150	QC	30 pcs		11/16/17	0.00	0.00	QC7		DAS
160	Powdercoat	30 pcs		11/17/17	0.00	0.53	Powdercoat1		38
170	QC	30 pcs		11/17/17	0.00	0.00	QC3		9-89
180	Packaging	30 pcs		11/17/17	0.00	0.00	Packaging3		Chantal Lavoie 17-12-22
190	QC21-SA	30 Ea		11/17/17	0.00	0.00	QC21		Chantal Lavoie 17-12-22

Part Op 110 - ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005

Descriptions: 120 - Ensure C of C is attach

160 - START TIME: _____

DAS
21
9-89

JAN 09 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
110-Purchasing	D2423	4	471	0	0
	D3910-1P	30	0	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Lug	4.450Inches ± 0.030	4.480 4.420		
2	Crosstube Lug	1.380Inches ± 0.030	1.410 1.350		
3	Crosstube Lug	0.270Inches ± 0.030	0.300 0.240	reference	
4	Crosstube Lug	0.310Inches ± 0.030	0.340 0.280		
5	Crosstube Lug	0.735Inches ± 0.010	0.745 0.725	reference	
6	Crosstube Lug	2.200Inches ± 0.030	2.230 2.170		
7	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365		
8	Crosstube Lug	0.191Inches	0.196	Diameter	

DART
AEROSPACE
S026855



Crosstube Lug

PART NO: D3910 - 1

Revision:

Operation:

Change No:

Purchasing

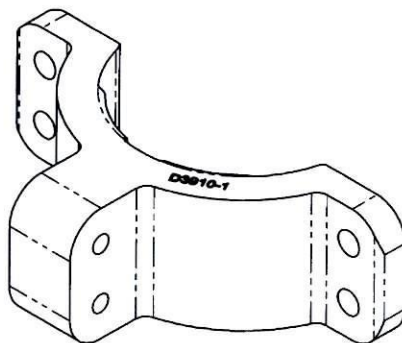
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 12/22/17

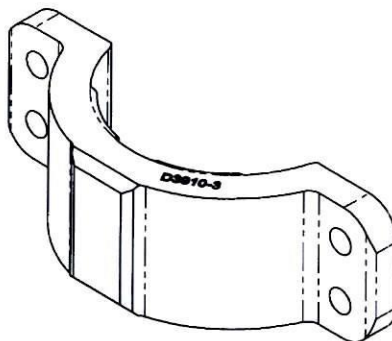
Job No: 167535

			+ 0.005	0.190	
			- 0.001		
9	Crosstube Lug	0.380Inches ± 0.030	0.410	Radius	
			0.350		
10	Crosstube Lug	0.380Inches ± 0.030	0.410		
			0.350		
11	Crosstube Lug	0.625Inches ± 0.010	0.635		
			0.615		
12	Crosstube Lug	0.375Inches ± 0.010	0.385		
			0.365		
13	Crosstube Lug	3.700Inches ± 0.010	3.710		
			3.690		
14	Crosstube Lug	0.625Inches ± 0.010	0.635		
			0.615		
15	Crosstube Lug	0.375Inches ± 0.010	0.385		
			0.365		
16	Crosstube Lug	0.340Inches ± 0.030	0.370	Radius	
			0.310		

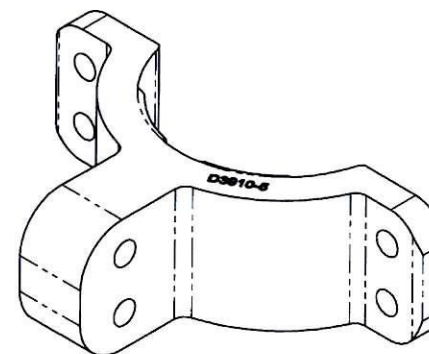
Plex 11/2/17 9:23 AM DART.LAVOIE.CHANTAL



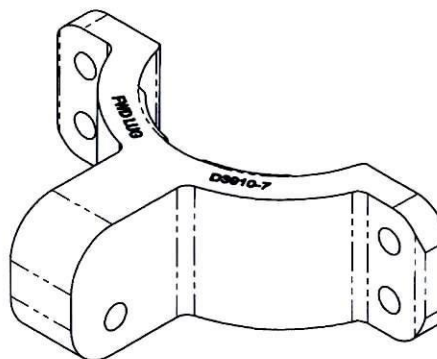
D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG



D3910-7 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005

RELEASED

2014 JUN 05

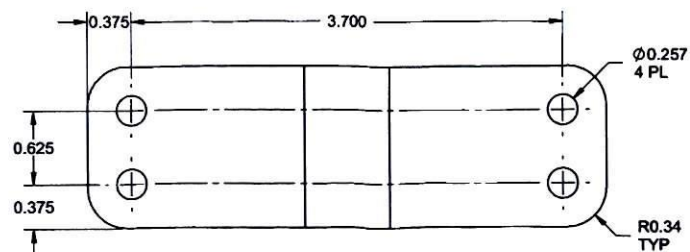
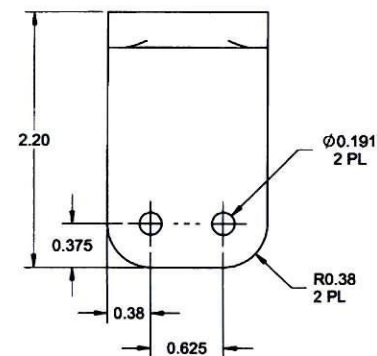
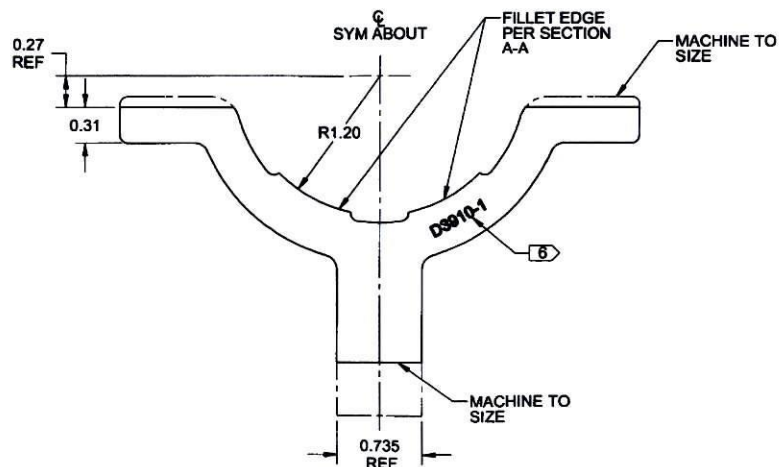
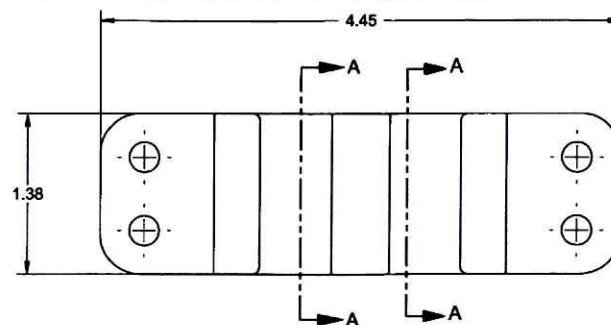
ECN 14-572

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-807-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350) SCALE NTS	
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG

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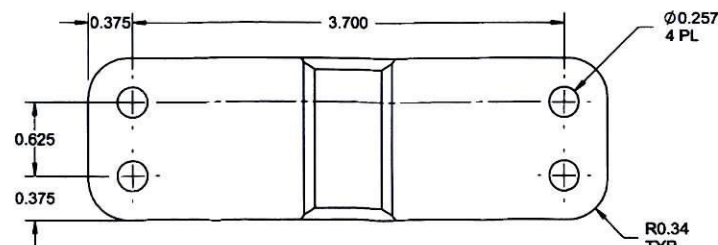
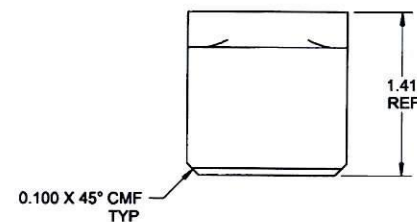
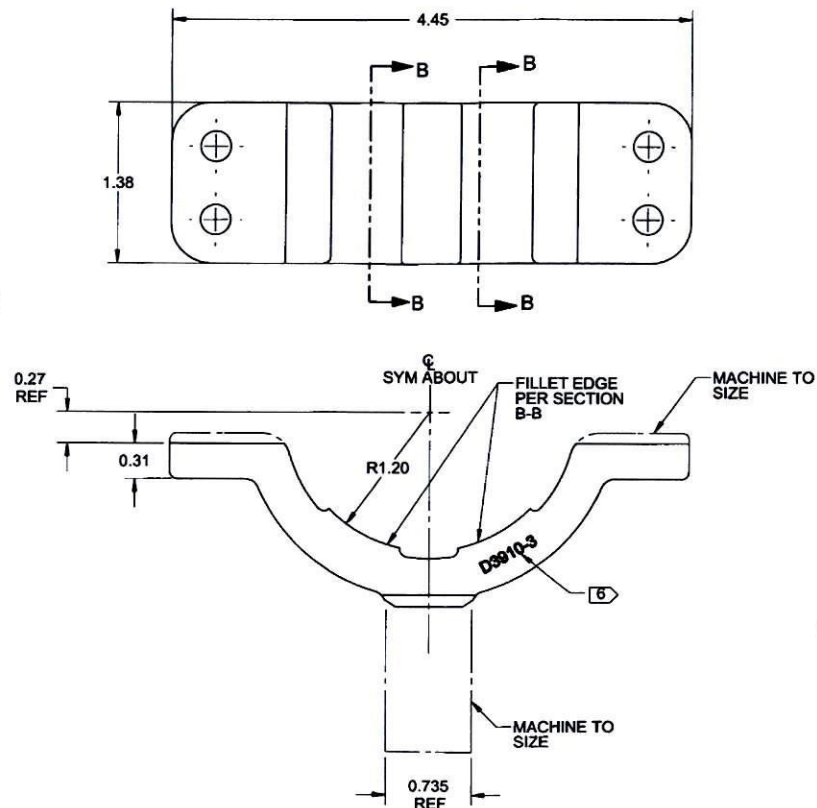
2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
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SECTION B-B



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-3 X-TUBE LUG

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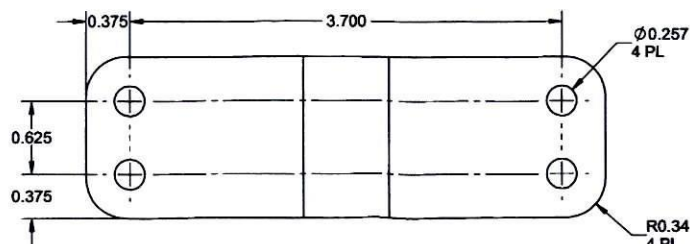
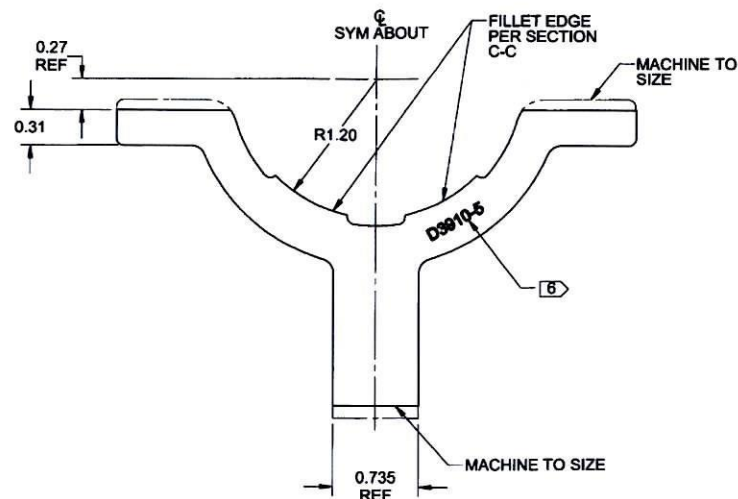
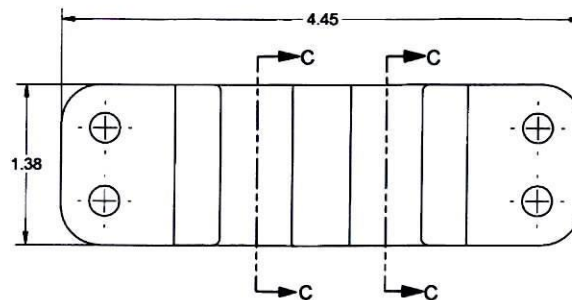
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MFG. APPR.	[Signature]	D3910	SHEET 3 OF 5
APPROVED	[Signature]	TITLE	SCALE
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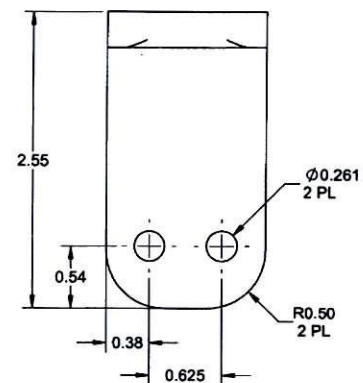


ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION C-C



D3910-5 X-TUBE LUG



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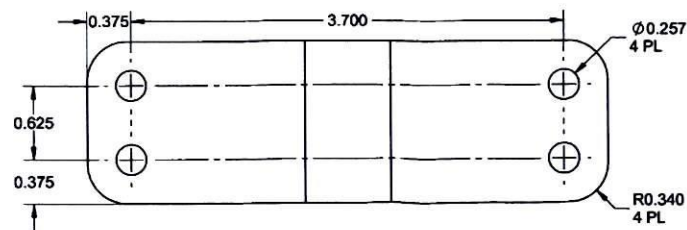
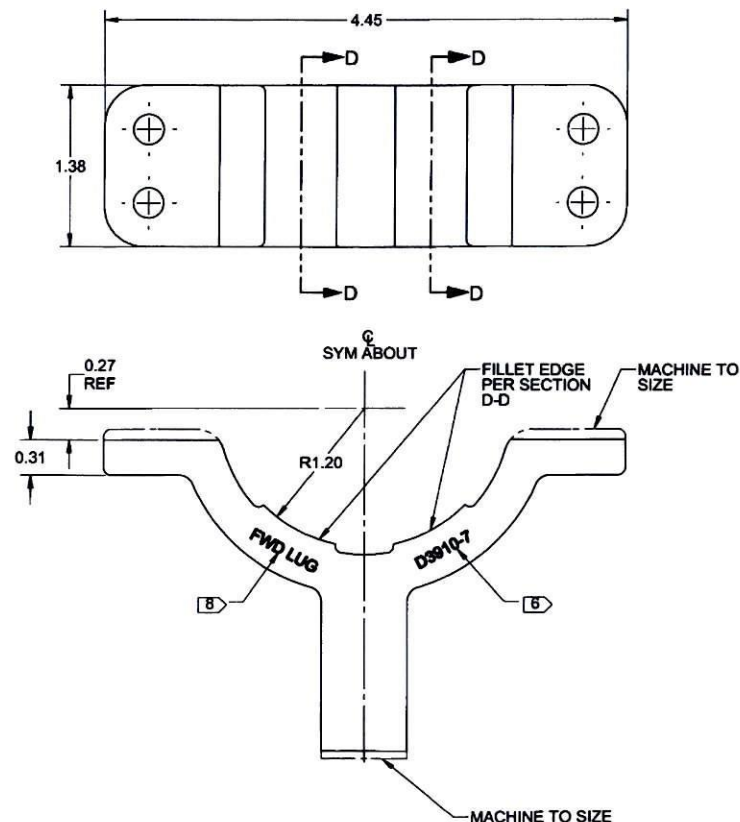
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APPROVED		TITLE	SCALE
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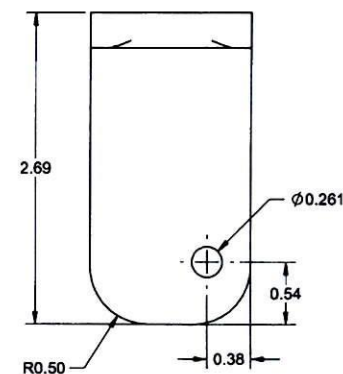
SECTION D-D



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-7 X-TUBE LUG



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2014 JUN 05

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MFG. APPR.		D3910	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038228

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038228

PO Date: 11/2/17

Due Date: 11/23/17

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments: Note: alodine and paint as per QSI 005

REVISED

Items

Line Item	Part	Rev	Supplier Part No	Item No	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D2230-1P				Lug As per Dwg D2230 Rev. G		Firmed	11/23/17	160 Ea	0 Ea	160 Ea	\$12.88/Ea	\$2,060.80
Line Item Note job# 167531													
2	D2230-3P				Lug As Per Dwg D2230 Rev. G		Firmed	11/23/17	210 pcs	0 pcs	210 pcs	\$14.00/pcs	\$2,940.00
Line Item Note job# 167532													
3	D3235-1P				Lug As Per Dwg D3235 Rev. A		Firmed	11/23/17	150 pcs	0 pcs	150 pcs	\$15.00/pcs	\$2,250.00
Line Item Note job# 167533													
4	D3910-1P				Crosstube Lug As Per Dwg D3910 Rev. E		Firmed	11/23/17	30 Ea	0 Ea	30 Ea	\$12.88/Ea	\$386.40
Line Item Note job# 167535													
5	D3910-3P				Crosstube Lug As Per Dwg D3910 Rev. E		Firmed	11/23/17	40 pcs	0 pcs	40 pcs	\$13.00/pcs	\$520.00
Line Item Note job# 167536													
6	D3910-5P				Crosstube Lug As per Dwg D3910 Rev. E		Firmed	11/23/17	30 Ea	0 Ea	30 Ea	\$12.88/Ea	\$386.40
Line Item Note job# 167537													
7							Firmed	11/23/17	20 Ea	0 Ea	20 Ea	\$12.88/Ea	\$257.60



20 Terry Fox Drive
 Vankleek Hill, Ontario K0B 1R0 , Canada
 Tel: (613) 678-3957
 Fax: (613) 678-3956

Delivery Slip No.: 22314
Date: Dec 22, 2017
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO038228	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Dec 22, 2017

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
D2230-1 Mounting Lug Alodine and Paint as per QSI 005		Each	200	40	
D2230-3 Mounting Lug Alodine and Paint as per QSI 005		Each	300	90	
D3235-1 Mounting Lug Alodine and Paint as per QSI 005		Each	160	10	
D3910-1 Crosstube Lug Alodine and Paint as per QSI 005		Each	30	30	
D3910-3 Crosstube Lug Alodine and Paint as per QSI 005		Each	40		
D3910-5 Crosstube Lug Alodine and Paint as per QSI 005		Each	30		
D3910-7 Crosstube Lug, as per drawing D3910 Rev.E Alodine and Paint as per QSI 005		Each	20		
D4091-1 Lug as per drawing D4091 Rev.A Alodine and Paint as per QSI 005		Each	30		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
Received by _____			Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
10	D3235-1	Lug Paint Batch # 21566	Material B160522 38228
90	D2230-3	Lug Paint Batch # 21597	Material B160522 38228
40	D2230-1	Lug Paint Batch # 21597	Material B160522 38228
30	D3910-1	Lug Paint Batch # 21566	Material B160522 38228

Material supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, December 22, 2017